

Date: Thursday, 2/1/2007 2:48:25 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARMOR SHIELD
 Job Number : 30573
 Estimate Number : 12366
 P.O. Number : N/A
 This Issue : 2/1/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LANDING GEAR
 Previous Run : 27360
 Written By :
 Checked & Approved By : 07.02.01
 Comment : Est Rev: A New Issue 06-04-19 JLM

Part Number : D212664101A
 Drawing Number : DSI9326
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 2/9/2007 Qty:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD212-664-101A CHG001
 Add DSI 9326 to existing paper work.

K-5 07.02.05 (1)

2.0 D212664101 Crosstube Installation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Fwd Crosstube
 Batch: 529502 ml 07 02 03 (1)

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 1-Remove tube from packaging

2-Apply Armor shield as per DSI 9326
 A/R Armor Shield Batch: ml 07 02 03 (1)

4.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ce 7/2/13 (1)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and pack for shipping as per PPP D212-664-101A
 Location:
 PPP Rev: DATA Ce 7/2/13 (1)

DART
 TRANSPORT CANADA APPROVAL # 09-89
 TEL: 1-613-632-3336
 FAX: 1-613-632-4443

P/N	D212-664-101	CHG	CHG002
DESC.	Crosstube Fwd High	STC	SH01-9
LOT	B29502	STC	SR01298NY
MODEL	Bell 204/205/212/214/412	STC	

MADE IN CANADA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/02/13

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ARMOR SHIELD

Job Number: 30573

Part Number: D212664101A

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

2071021/13

Job Completion



U 2071021/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED J. J.	APPROVED H	DRAWING NO. DSI 9326	REV. A SHEET 1 OF 1
DATE 06.02.14		TITLE ARMOR SHIELD	SCALE NTS
A	06.02.14	NEW ISSUE	

DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment.

INSTALLATION	CANADIAN STC	FAA STC
D205-596-101/-103/-105/-107	SH03-6	SR01742NY
D212-664-101/-201	SH01-9	SR01298NY
D412-664-203		
D206-667-101/-103/-201/-203	SH01-5	SR01304NY
D407-667-105/-205		
D058-676-101/-201	N/A	SR01018SE

To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. It is acceptable to apply the Armor Shield in regions shown in Figure 1 only. It is **NOT** acceptable to apply Armor Shield in the cuff and support/clamp regions.

1.0 To apply Armor Shield

- 1) Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 2) Mask areas around supports and cuffs per Figure 1. Abrade paint finish in areas requiring protection using 320 grit sandpaper.
- 3) Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area
- 4) Apply 3 coats of Proform PF 746 or PF 746-1 to surface (apply additional coats when surface is dry, but not fully cured)
- 5) Allow 5 hours for coating to dry.
- 6) Apply 2 coats of Imron 500s Polyurethane Enamel clear + Dupont Imron Polyurethane Enamel Activator 192S (mix 3:1). Mix 15 minutes prior to application and allow 15 minutes before applying additional coats.

2.0 Armor Shield removal/re-application

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 1) Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2) Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 3) Apply Armor Shield in accordance with Section 1.0 of these instructions.

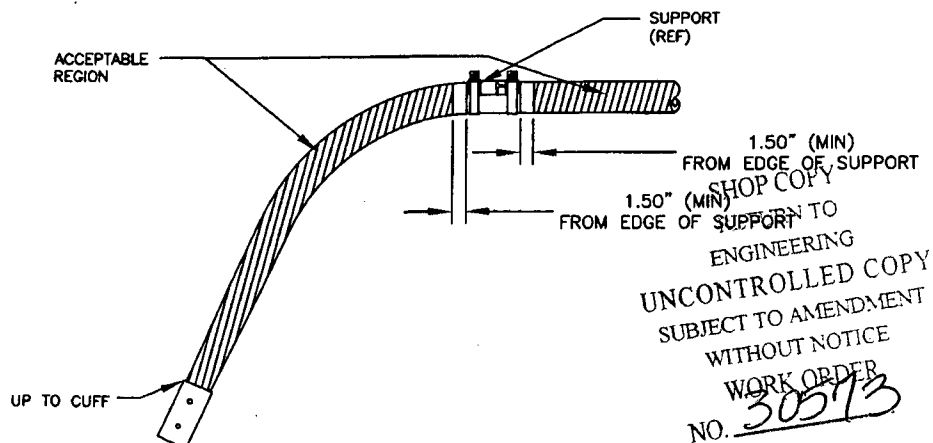


FIGURE 1 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.02.14
CERT. NO.: SH03-6/SH01-9/SH01-5
ISSUE NO.: 3/3/3

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